

Work Order ID 86972

July-11-12 12:43:03 PM

86972

Page 1

Item ID: D3027-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Clip

Stop

NS2

Start Date: 10/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/08/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MWJ

Date: 12/07/11

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(10)			
D3027	Rev B								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT AS PER DWG								
2624 . 050	DWG REV: <u>B</u>								
	PROG REV: <u>B</u>								
	DEBURR								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

B12-7-24

B12-7-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clip

Stop ***NS2***

Start Date: 10/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/08/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	NC Brake	0.00							
150	QC 5 inspection	0.00							
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

SMBS
12-7-24

DAS
16
2-83
12/14/25

10

10

12/14/25

DAS
16
2-83

12/14/25

10

12-7-26

MT

10X

12/17/26

W/O:		WORK ORDER CHANGES					
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Page 3

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 10/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/08/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>2p</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

100 12/7/26 sf

12/7/30

MUT 12/07/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

July-11-12 12:43:06 PM

Page 1

Work Order ID: 86972

86972

Parent Item: D3027-3

D3027-3

Parent Item Name: Clip

Start Date: 10/07/2012

Required Date: 10/08/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B01.09.27Now goes on HAASSM IPP
REV:C NOW ON WATERJET JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	253.5000	0.0312	0.197053	.5		

M2024T3S 050

2024-T3 .050 sheet

**

IB 12-7-24

Location

Loc Qty

Loc Code

MAT022

253.5

117684

22.8

121216

89.2

121889

141.5

121889

10

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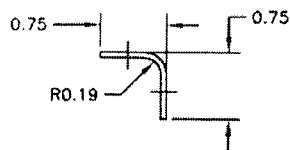
NOTE: Date & initial all entries

DART

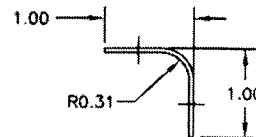
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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3027
				REV. B
DATE	05.09.20	TITLE	CLIP	SHEET 1 OF 2
				SCALE 1:2
A	01.05.18	NEW ISSUE		
B	05.09.20	REMOVE HOLES FROM -7		

RELEASED

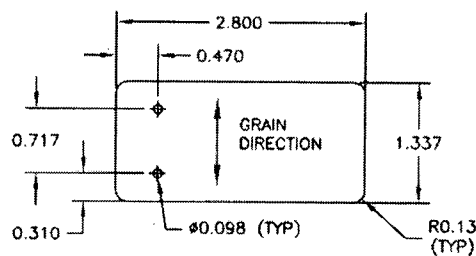
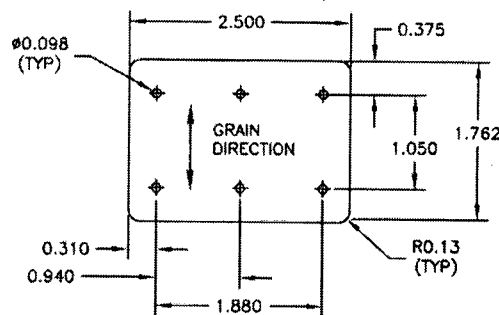
05.10.03



D3027-1 BEND DETAIL



D3027-3 BEND DETAIL

D3027-1 FLAT PATTERN
(0.063" SHEET)D3027-3 FLAT PATTERN
(0.050" SHEET)

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86932 MJS
12/07/10

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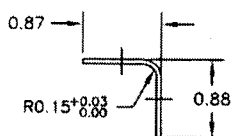
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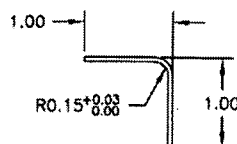
DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3027	REV. B SHEET 2 OF 2
DATE 05.09.20		TITLE CLIP	SCALE 1:2

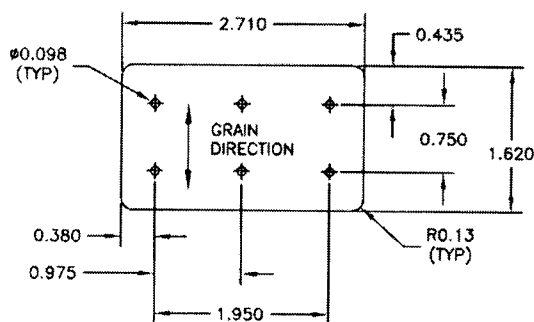
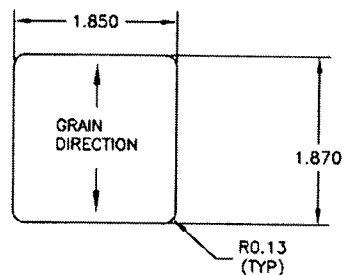
RELEASED

05.10.23 *[Signature]*

D3027-5 BEND DETAIL



D3027-7 BEND DETAIL

D3027-5 FLAT PATTERN
(0.050" SHEET)D3027-7 FLAT PATTERN
(0.050" SHEET)

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96972

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